







Date: Thursday, 8/30/2007 3:49:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 34352	
Estimate Number : 12785	
P.O. Number : N/A	Part Number : D356411
This Issue : 8/30/2007 S.O. No. : N/A	Drawing Number : D3564 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33799	Material : N/A
Written By : <u>07.08.31</u>	Due Date : 9/18/2007
Checked & Approved By : <u>07.08.31</u>	Qty: <u>40</u> Um: Each
Comment : Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S16GA 304/316 .063 Sheet
	
Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M10530 IB 07-09-01</u>	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: <u>C</u> Prog Rev: <u>C</u> <u>IB 07-09-01</u>	
2-Deburr if necessary <u>IB 07-09-12</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 07-09-01</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>IB 07-09-12</u> <u>440</u> <u>contg</u>	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT <u>8179</u> and DT <u>8157</u> <u>IB 07-09-19</u>	

Dart Aerospace Ltd

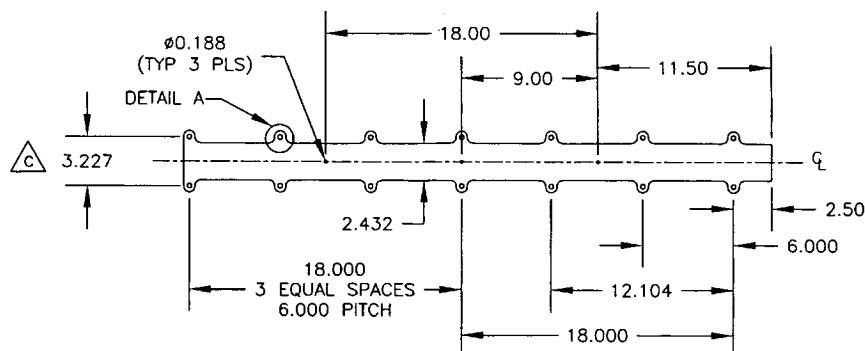
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

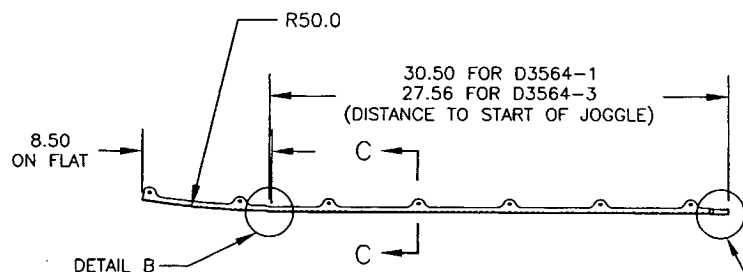
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

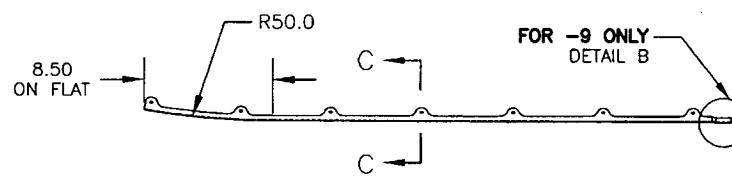
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

UNDER REVIEW

07.03.17 CB

add by wearplate

CB 07.08.30

RELEASED
07.06.28

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

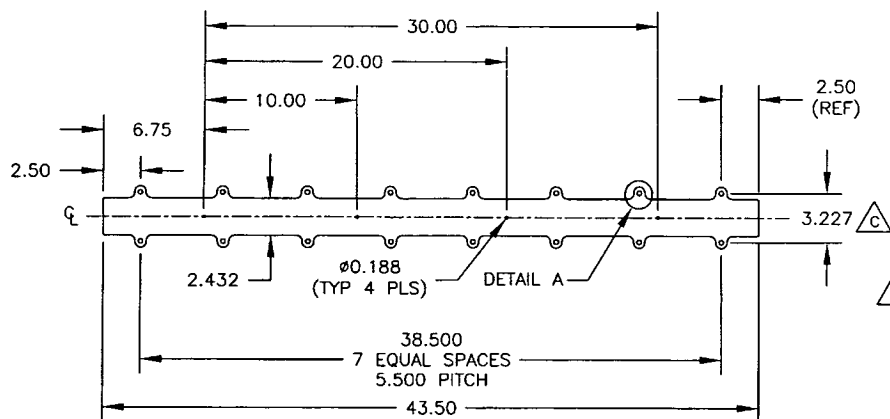
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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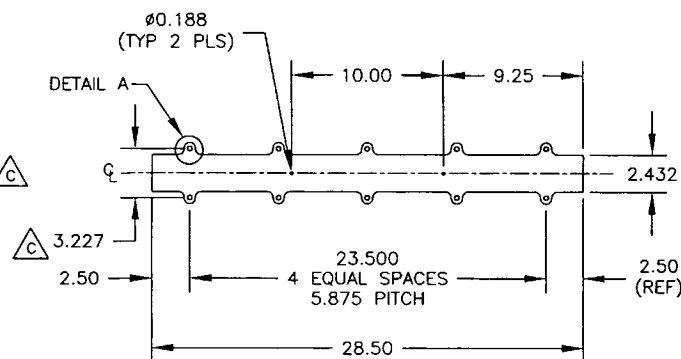
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DART AEROSPACE LTD.

C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WILMINGTON, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	07.04.17	TITLE WEARSHOE
		REV. C SHEET 1 OF 2 SCALE 1:8

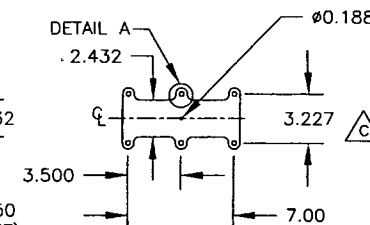
NO. 34352
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



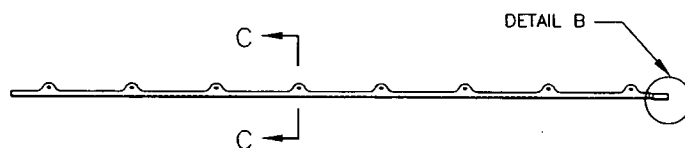
D3564-5F FLAT PATTERN



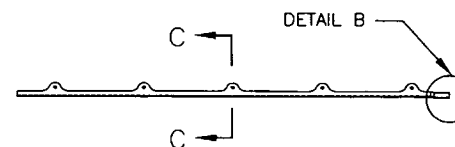
D3564-7F FLAT PATTERN



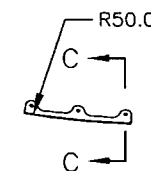
D3564-13F FLAT PATTERN



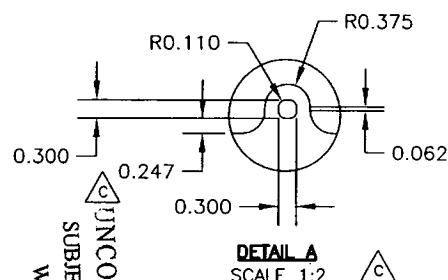
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



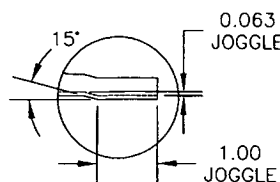
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



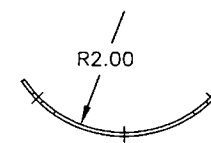
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

NO. 34352
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

07.08.30
CB

UNDER REVIEW

07.08.21 CB
adding wear-plate

RELEASED
07.08.28

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564	REV. C SHEET 2 OF 2
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:8

DART AEROSPACE LTD		Work Order: 345
Description: WEAR PAD		Part Number: P3544-11
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[illegible]